

Work Order ID 50015

July 2, 2009 3:48:44 PM



Page 1

Item ID: D2229

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 07/06/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 07/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2229

Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2229 Dwg Rev: B Prog Rev: B
Deburr if necessary

m 09 07 07 10
Deburr m 09 07 07 10
10X

110



QC2- Inspect parts off machine FAI/FAIB

0.00

m 09 07 07 10

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

⇒ 09/07/07 10

QC

Memo

0.00

Quality Control

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Cust Item ID:

Required Date: 07/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



Operation
Description

Small Fab

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Small Fab

Memo

0.00

m-h 09/07/08 10X

140



Chemical Conversion Coat per QSI005 4.1

0.00

ff 09-07-09 X10

HandFinish

Memo

0.00

Hand Finishing

150



QC3- Inspect Part Finish

0.00

09-07-09 10

QC

Memo

0.00

Quality Control

BR

Work Order ID 50015

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Item ID: D2229

Accept



Setup

Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 07/06/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 07/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



Packaging

Packaging

Identify as per dwg & Stock Location: 24Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

9/7/9 561 10x

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

09/07/09 48

Memo

0.00

mf 09-07-09

Picklist Print

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Page 1

Work Order ID: 50015



Parent Item: D2229RevB



Parent Item Name: Doubler

Start Date: 07/06/2009

Required Date: 07/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	168.8200	0.5484			

2024-T3 .063 sheet



Warehouse

Location

Main Warehouse

MAT	Loc Qty	Loc Code
102942	1.5	
105916	3.69	
106223	1.47	
109463	24.2	
110980	15.45	
111787	120.51	
19059	2	

ml . ml

DART AEROSPACE LTD	Work Order:	50015
Description: Doubler	Part Number:	D2229
Inspection Dwg: D2229	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>M.W</i>	Audited by:	<i>S</i>	Prototype Approval:	N/A
Date:	09/07/07	Date:	09/07/07	Date:	N/A

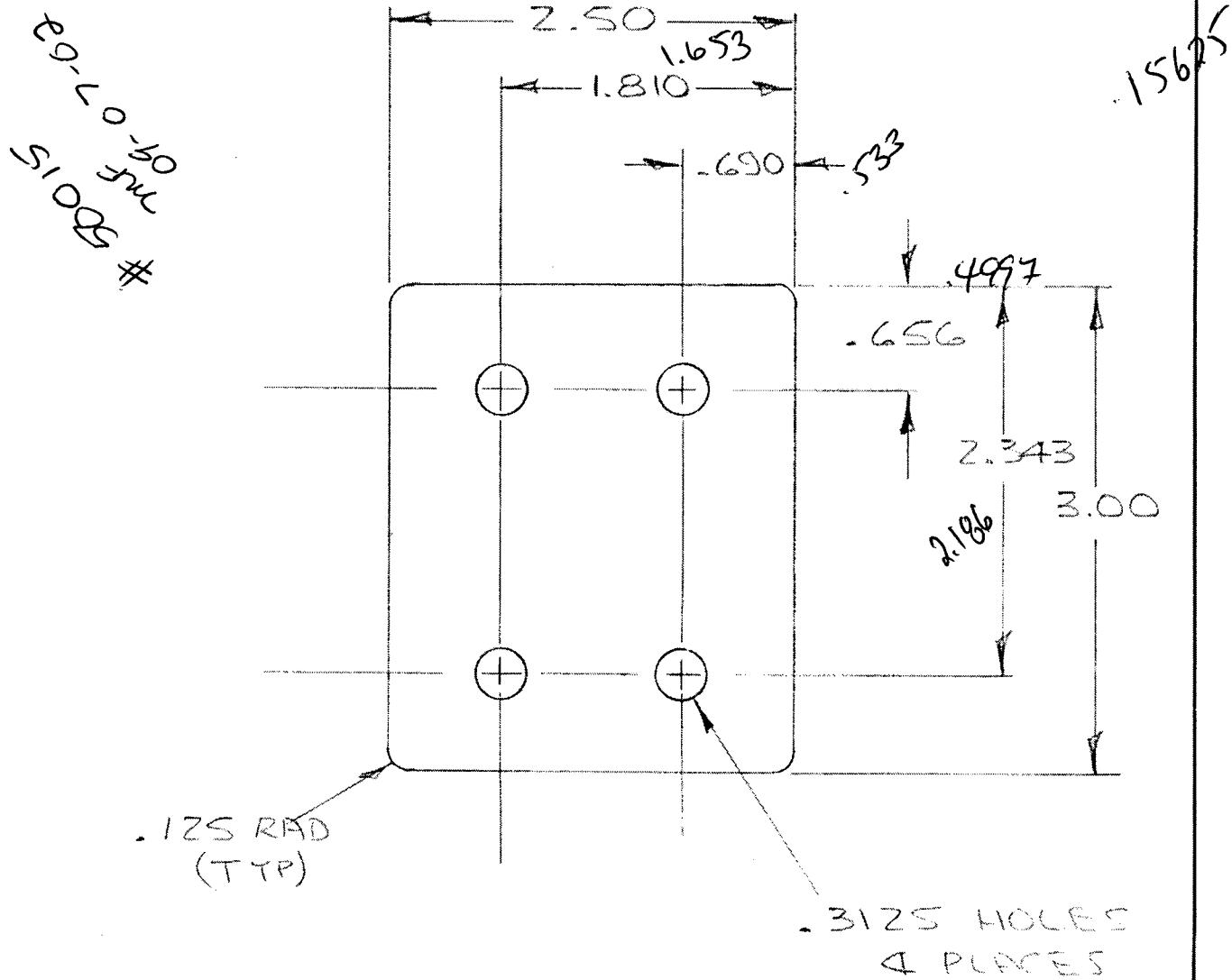
Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	E

DART

SEARCHED
INDEXED
FILED

DRAWN BRADLEY 94-3-28	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA		
DESIGN BRADLEY 94-3-28	DRAWING NO. D2229	REV. B	SHEET 1 OF 1
	TITLE DOUBLER		

A	NEW ISSUE	94/3/b8	4
B	ALODINE w/ ANODIZE	93/1/66	6



MATERIAL: 2024-T3 ALUMINUM
.063 THICK

FINISH: ALODINE PER ASI 005-4.1